

5/13

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 22514 A
<b>Description:</b> Bracket Assembly	<b>Part Number:</b> D2803-042
<b>Dwg:</b> D2803 Rev. B	<b>Qty:</b> 5 <del>20</del>
Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler <b>Dwg not required</b>	PA	05.02.23	20																				
2	GA	Press D2805-2 into arm as per Dwg D2803 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2803-2</td><td>Bracket B 22524A</td><td>B 22524B</td></tr><tr><td>1</td><td>D2805-2</td><td>Stop</td><td>B 22521</td></tr><tr><td>1</td><td>D2809</td><td>Bushing</td><td>B 22529</td></tr></table>	Qty	Part Number	Description	Batch	1	D2803-2	Bracket B 22524A	B 22524B	1	D2805-2	Stop	B 22521	1	D2809	Bushing	B 22529	SB	05/03/28	20 5				
Qty	Part Number	Description	Batch																						
1	D2803-2	Bracket B 22524A	B 22524B																						
1	D2805-2	Stop	B 22521																						
1	D2809	Bushing	B 22529																						
3	QC5	Inspect work to Step 2	Z	05.03.28	20 5																				
4	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	M	05.03.29	20																				
5	QC3	Inspect Powder Coat	SB	05/03/29	5																				
6	GA	Press D2809 into arm as per Dwg D2803	SB	05/03/30	5																				
7	GA	Spray LPS-3 on Bolt Shaft, <b>not</b> on thread as per Dwg D2803 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN3C16A</td><td>Bolt</td><td>M 17046</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M 16941</td></tr><tr><td>4</td><td>NAS1515H3</td><td>Washer</td><td>M 16941</td></tr><tr><td>A/R</td><td>LPS-3</td><td>Corrosion Spray</td><td>M 16863</td></tr></table>	Qty	Part Number	Description	Batch	2	AN3C16A	Bolt	M 17046	2	MS21042L3	Nut (or -3)	M 16941	4	NAS1515H3	Washer	M 16941	A/R	LPS-3	Corrosion Spray	M 16863	SB	05/03/30	5
Qty	Part Number	Description	Batch																						
2	AN3C16A	Bolt	M 17046																						
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4	NAS1515H3	Washer	M 16941																						
A/R	LPS-3	Corrosion Spray	M 16863																						
8	GA	Assemble as per Dwg D2803.	SB	05/03/30	5																				
9	QC5	Inspect work to Step 8	Z	05.03.30	5																				
10	ST	Identify and Stock	SB	05/03/30	5																				
11	AC	Cost / part: 81.07	Sur	05.04.01	5																				
12	DC	Close W/O 81.07 Inspect Level 21	PA	05.04.05	5																				

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Revise pick list	EC	
C	01.03.02	Added D2809 to pick list	EC	
D	01.04.26	Reformat	EC	
E	05.02.22	Revised Step 7	KJ/JLM	

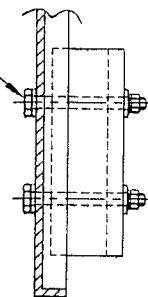
RELEASED  
05/03/2023





DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3

AN3C16A BOLT (1)  
NAS1515H3 WASHER (2)  
MS21043-3 NUT (1)  
INSTALL BOLT WITH LPS-3 CORROSION  
INHIBITOR (ENSURE NO LPS-3 ON THREADS)  
(2 PLACES)



SECTION D-D  
SCALE 1:3  
(ROTATED)

USE D2803-1 FOR D2803-041/-043  
USE D2803-2 FOR D2803-042/-044

USE D2805-1 FOR D2803-041  
USE D2805-2 FOR D2803-042  
USE D2805-3 FOR D2803-043  
USE D2805-4 FOR D2803-044  
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE  
PRIOR TO POWDER COAT

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WITHOUT NOTICE

WORK ORDER

RELEASED

05-03-11

22514

D2803-041/-043 BRACKET ASS'Y (SHOWN)  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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## Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 22, 2005  
03:39 pm

Work Order No	: 0022514	Department Code:	
Project Name	: D2803-042	Burden Flags	: NNNNNNNN
Project For	: WK513	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2803-042	Invoice Number	:
Description	: Bracket Assembly	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 20	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 02-22-05		
Est Finish Date	: 03-15-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====	=====	=====	=====	=====	=====
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====	=====	=====	=====		
Burden	: 0.00	0.00	0.00		
=====	=====	=====	=====		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00